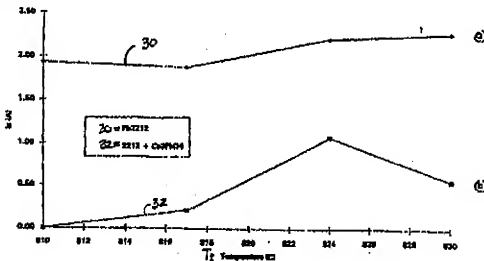




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(54) Title: **PRODUCTION AND PROCESSING OF (Bi, Pb)SCCO SUPERCONDUCTORS**

(57) Abstract

A novel process of the production and processing of high quality, high  $T_c$  (Bi, Pb)SCCO superconductors starts with fabrication of a precursor article including selected intermediate phases with desired chemical and structural properties. The precursor fabrication includes mixing raw powders with a desired ratio of Bi:Pb:Sn:Ca:Cu elements and reacting the mixture under different selected reaction conditions that form a precursor powder with a dominant (Bi, Pb)SCCO 2212 phase and without Ca-Pb-O phase, wherein the 2212 phase may be the orthorhombic 2212 phase. The precursor article is then subjected to optimized reaction and mechanical deformation processes that lead to a reaction induced texturing and deformation induced texturing, respectively. A heating process is used to convert the precursor powder to the 2223 phase and subsequent deformation and annealing processes may be used to form a substantially single phase, highly textured (Bi, Pb)SCCO 2223 superconductor with high  $J_c$ .

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## PRODUCTION AND PROCESSING OF (Bi,Pb)SCCO SUPERCONDUCTORS

### Background of the Invention

The present invention relates to the production and processing of high  $T_c$  superconducting bismuth-strontium-calcium-copper-oxide materials.

Since the discovery of the copper oxide ceramic superconductors, their physical and chemical properties have been widely studied and described in many publications, too numerous to be listed individually.

These materials have superconducting transition temperatures ( $T_c$ ) greater than the boiling temperature (77K) of liquid nitrogen. However, in order to be useful for the majority of applications at 77K or higher, substantially single phase superconducting materials with high critical current densities

(Jc) are needed. In general, this requires that the grains of the superconductor be crystallographically aligned, or textured, and well sintered together. Several members of the bismuth-strontium-calcium-copper-oxide family (BSCCO), in particular,  $\text{Bi}_2\text{Sr}_2\text{CaCu}_2\text{O}_x$  (BSCCO 2212) and  $\text{Bi}_2\text{Sr}_2\text{Ca}_2\text{Cu}_2\text{O}_{10}$  (BSCCO 2223) have yielded promising results, particularly when the bismuth is partially substituted by dopants, such as lead ((Bi,Pb)SCCO).

Composites of superconducting materials and metals are often used to obtain better mechanical properties than superconducting materials alone provide. These composites may be prepared in elongated forms such as wires and tapes by a well-known process which includes the three stages of: forming a powder of superconductor precursor material (precursor powder formation stage); filling a noble metal container, such as a tube, billet or grooved sheet, with the precursor powder and deformation processing one or more filled containers to provide a composite of reduced cross-section including one or more cores of superconductor precursor material in a surrounding noble metal matrix (composite precursor

- fabrication stage); and subjecting the composite to successive physical deformation and annealing cycles and further thermally processing the composite to form and sinter a core material having the desired superconducting properties (thermomechanical processing). The alignment of precursor grains in the core ("textured" grains) caused by the deformation process facilitates the growth of well-aligned and sintered grains of the desired superconducting material during later thermal processing stages.

- The general process, commonly known as "powder-in-tube" or "PIT", is practiced in several variants depending on the starting powders, which may be, for example, metal alloys having same metal content as the desired superconducting core material in the "metallic precursor" or "MPIT" process, or mixtures of powders of the oxide components of the desired superconducting oxide core material or of a powder having the nominal composition of the desired superconducting oxide core material in the "oxide powder" or "OPIT" process. General information about the PIT method described above and processing of the oxide superconductors is provided by Sandhage et al., in JOM, Vol. 43, No. 3 (1991) pages 21 through 25, and the references cited therein.

- OPIT precursor powders are prepared by reacting raw powders such as the corresponding oxides, oxalates, carbonates, or nitrates of the metallic elements of the desired superconducting oxide. Because the OPIT precursor powder is formed by chemical reaction, its actual phase composition will depend on the quality and chemical composition of the starting materials and on the processing conditions, such as temperature, time, and atmosphere. Different processing conditions will give rise to different phases or different ratios of phases. If secondary phases, such as calcium plumbate ( $\text{Ca}_2\text{PbO}_4$ ), are formed in relatively large amounts, they can give rise to undesired effects. The presence of calcium plumbate, for example, disrupts the deformation induced texturing of the primary phase

- of the precursor powder, results in gas evolution during thermal processing, leads to growth of certain undesirable alkaline earth cuprate (AEC) phases which do not participate in the conversion of the precursor into the final oxide superconductor, and may induce undesired melting during heat treatments.

- In order to avoid undesirable secondary phase formation, precursor powders sometimes are prepared by forming a BSCCO superconductor phase in a separate synthesis step and combining the BSCCO superconductor phase with a second metal oxide. The two powders may be readily reacted in a subsequent thermal processing step into the final oxide superconductor. By preparing the BSCCO superconductor in a separate reaction, it may be possible to avoid inclusion of undesirable secondary phases in the precursor powder.

- A typical prior art preparation involves preparing essentially single phase (Bi,Pb)SCCO 2212 in a separate reaction and combining it with an alkaline earth cuprate. In subsequent thermal reactions, the two metal oxides react to form (Bi,Pb)SCCO 2223. The prior art reaction process is less than optimal because combining separate oxide powders necessarily reduces the intimate contact between the reactants (resulting in inhomogeneity), thereby requiring longer reaction times and/or harsher reaction conditions in order to obtain the final product. The slower reaction kinetics results in reduced control over the reaction process.

- It is desirable, therefore, to have a method for preparing precursor powders having a controlled phase composition in a single step reaction process. It is further desirable to provide a method of controlling the phase composition of the precursor powder during its preparation and during subsequent thermomechanical processing.

Summary of the Invention

The present invention provides a means of preparing a precursor powder for the BSCCO superconducting materials, particularly Pb-doped BSCCO materials, with selected primary and secondary phases and of  
5 controlling the phase composition of the precursor powder during its preparation and during subsequent thermomechanical processing steps. In general, in one aspect, the invention provides an improved precursor powder for the production of BSCCO superconducting material, and a process for making this precursor powder, while in another aspect it  
10 provides an improvement in processing of the precursor powder during the thermomechanical processing of the powder into the desired superconducting material.

In one aspect of the invention, a method for the production and processing of BSCCO superconducting material includes the steps of  
15 providing a mixture comprising raw materials of a desired ratio of constituent metallic elements corresponding to a final superconducting BSCCO material, and heating said mixture at a selected temperature in an inert atmosphere with a selected oxygen partial pressure for a selected time period. The processing temperature and the oxygen partial pressure are  
20 cooperatively selected to form a dominant amount of an orthorhombic BSCCO phase in the reacted mixture.

By "final BSCCO superconducting material", as that term is used herein, it is meant the chemical composition and solid state structure of the superconducting material after all processing of the precursor is  
25 completed. It is typically, though not always, the oxide superconductor phase having the highest  $T_c$  or  $J_c$ .

By "dominant amount" of the orthorhombic BSCCO phase, as that term is used herein, it is meant that the orthorhombic phase is the dominant phase present in the precursor powder, as selected among the  
30 members of the homologous BSCCO series of oxide superconductor. A

"dominant amount" includes more than 50 vol%, preferably more than 80 vol%, and most preferably, more than 95 vol% of the members of the homologous BSCCO series as the orthorhombic phase.

- Reference to the "orthorhombic phase" recognizes the existence of
- 5 two crystallographic structures for BSCCO superconducting materials, the tetragonal and the orthorhombic structures. The conversion of the tetragonal to the orthorhombic structure corresponds to the formation of an oxygen deficient structure. The conversion occurs simultaneously with the complete incorporation of a substituent having a variable oxidation
- 10 state, i.e., Pb or Sb, into the BSCCO structure. Since the dopant typically exists in an oxide phase, such as for example,  $\text{Ca}_2\text{PbO}_x$ , the conversion from the tetragonal to the orthorhombic does not occur until all the dopant is consumed. Thus the formation of the orthorhombic phase is indicative of the complete reaction of the dopant carrier. The formation
- 15 of the orthorhombic phase is indicated by the splitting of the XRD 200 and 020 peaks at  $33^\circ (2\theta)$ .

- In a preferred embodiment, the final superconducting material includes a BSCCO-2223 phase. In another preferred embodiment, the final superconducting material includes a (Bi,Pb)SCCO-2223 phase. In another
- 20 preferred embodiment, the dominant orthorhombic phase includes a BSCCO-2212 phase. In yet another preferred embodiment, the dominant orthorhombic phase includes a doped BSCCO-2212 phase, where the dopant substitutes for bismuth. The dopant may be lead (Pb) or antimony (Sb), and is preferably Pb.

- 25 In a preferred embodiment, the processing temperature and the oxygen partial pressure are cooperatively selected to form an alkaline earth cuprate phase, in addition to the dominant orthorhombic BSCCO phase, during the heating step. By "alkaline earth cuprate" or AEC, as that term is used herein, it is meant metal oxide phases including an alkaline earth,
- 30 such as calcium (Ca) and/or strontium (Sr) and including copper. There

may be one or more phases present in the precursor powder. The overall composition of the AEC may vary as the oxidation states of the constituent elements vary and as calcium and strontium substitute for each other. Suitable AECs, include, by way of example only,  $(\text{Sr}_x\text{Ca}_{1-x})\text{CuO}_2$ ,  $(\text{Sr}_x\text{Ca}_{1-x})_2\text{CuO}_3$ ,  $(\text{Sr}_x\text{Ca}_{1-x})\text{Cu}_2\text{O}_3$ . The AEC phases may also include single metal oxides, such as, by way of example,  $\text{CuO}$ ,  $\text{CaO}$  and  $\text{Cu}_2\text{O}$ .

In another preferred embodiment, the processing temperature and the oxygen partial pressure are cooperatively selected such that the oxygen partial pressure is below a value at which a  $\text{Ca-Pb-O}$  phase is formed and above a value at which said dominant orthorhombic BSCCO phase decomposes. In yet another preferred embodiment, the heating step includes maintaining the temperature of the mixture in a range of  $650^\circ\text{C}$  to  $795^\circ\text{C}$  and the oxygen partial pressure in a range of  $10^5$  atm  $\text{O}_2$  to  $0.04$  atm  $\text{O}_2$ , and preferably maintaining the temperature of the mixture in a range of  $720^\circ\text{C}$  to  $790^\circ\text{C}$  and the oxygen partial pressure in a range of  $10^4$  to  $10^2$  atm  $\text{O}_2$ .

In yet another aspect of the present invention, a  $(\text{Bi,Pb})\text{-Sr-Ca-Cu-O}$  superconducting material is prepared by providing a mixture of raw materials of a desired ratio of constituent metallic elements corresponding to a final superconducting  $(\text{Bi,Pb})\text{-Sr-Ca-Cu-O}$  material, and heating the mixture at a selected processing temperature in an inert atmosphere with a selected oxygen partial pressure for a selected time period, wherein the processing temperature and said oxygen partial pressure are cooperatively selected to eliminate, substantially, formation of a  $\text{Ca-Pb-O}$  phase.

In a preferred embodiment, the processing temperature and oxygen partial pressure are cooperatively selected to form alkaline earth cuprate phases, in addition to eliminating, substantially, formation of a  $\text{Ca-Pb-O}$  phase. In another preferred embodiment, the processing temperature and the oxygen partial pressure are cooperatively selected such that the oxygen partial pressure is below a value at which a  $\text{Ca-Pb-O}$  phase is formed. In



yet another preferred embodiment, the mixture is maintained at a temperature in a range of 650°C to 795°C and a oxygen partial pressure in a range of  $10^2$  atm  $O_2$  to 0.04 atm  $O_2$  during the heating step. In yet another preferred embodiment, the mixture is maintained at a temperature  
5 in a range of 720°C to 790°C and a oxygen partial pressure in a range of  $10^1$  atm  $O_2$  to  $10^2$  atm  $O_2$  during the heating step.

In yet another aspect of the present invention, an elongated BSCCO or (Bi,Pb)-Sr-Ca-Cu-O superconducting article is prepared. A mixture of raw materials of a desired ratio of constituent metallic elements  
10 corresponding to a final superconducting BSCCO or (Bi,Pb)SCCO 2223 material is provided. The mixture is heated at a first selected processing temperature in an inert atmosphere with a first selected oxygen partial pressure for a first selected time period, such that the first processing temperature and the first oxygen partial pressure are cooperatively selected  
15 to form a dominant amount of an orthorhombic BSCCO or (Bi,Pb)SCCO 2212 phase in the reacted mixture. The reacted mixture is introduced into a metal sheath, and sealed. The sealed sheath is deformed to form an elongated precursor article of a desired texture. The orthorhombic BSCCO or (Bi,Pb)SCCO 2212 phase is heated after the deforming step at a  
20 second selected processing temperature in an inert atmosphere with a second selected oxygen partial pressure for a second selected time period, such that second processing temperature and the second oxygen partial pressure are cooperatively selected to convert at least a portion of the orthorhombic BSCCO or (Bi,Pb)SCCO 2212 phase to the BSCCO or (Bi,  
25 Pb)SCCO 2223 superconducting material.

In a preferred embodiment, the first processing temperature and the first oxygen partial pressure are cooperatively selected to form a dominant amount of an alkaline earth cuprate phase, in addition to the dominant orthorhombic (Bi,Pb)SCCO 2212 phase. In another preferred  
30 embodiment, the steps deforming and second heating steps are repeated

one or more times. In another preferred embodiment, the heating step includes cooperatively selecting the second processing temperature and the second oxygen partial pressure, such that oxygen partial pressure is below a value at which a Ca-Pb-O phase is formed and above a value at which the dominant orthorhombic (Bi,Pb)SCCO 2212 phase decomposes. In yet another preferred embodiment, the heating step includes heating at a temperature in the range of 800°C to 845°C and preferably 800°C to 834°C and at an oxygen pressure in the range of 0.003 to 0.21 atm O<sub>2</sub>.

- In yet another preferred embodiment, the second heating step includes ramping through a temperature range and an oxygen partial pressure range, such that the temperature and oxygen partial pressure range cooperatively include a value at which a Ca-Pb-O phase is formed and/or a value at which the dominant orthorhombic (Bi,Pb)SCCO 2212 phase decomposes. The ramping is at a rate sufficiently rapid such that the formation of the Ca-Pb-O phase and decomposition of the dominant orthorhombic (Bi,Pb)SCCO 2212 phase is kinetically disfavored. In a preferred embodiment, the ramp rate is greater than 0.1 °C/min and preferably is in the range of 0.1 to 100 °C/min.

- The method of the present invention provides a precursor powder that substantially is free of undesirably secondary phases and which can be processed according to the above method of the invention to obtain a superconducting article having superior electrical properties.

#### Brief Description of the Drawing

- FIG. 1 depicts a three dimensional plot of relative Ca<sub>2</sub>PbO<sub>4</sub> formation in an orthorhombic (Bi,Pb)SCCO 2212 precursor powder at different temperature and P(O<sub>2</sub>);

FIG. 2 depicts the x-ray diffraction (XRO) patterns of deformed precursor powder composite tapes fabricated by the OPIT method in

which the tape was subjected to anneal (a) at 400°C in air; (b) at 600°C in nitrogen, and (c) at 600°C in air;

- FIG. 3 depicts the X-ray diffraction (XRD) patterns of the deformed precursor powder composite tapes fabricated by the OPTI method using an identical deformation process for composites containing (a) a predominant orthorhombic (Bi,Pb)SCCO 2212 phase, secondary AEC phases and no  $\text{Ca}_2\text{PbO}_4$  phase; and (b) a predominant tetragonal BSCCO 2212 phase, secondary AEC phases, and a  $\text{Ca}_2\text{PbO}_4$  phase;

- FIG. 4 depicts the dependence of the critical current  $I_c$  on the thermal reaction temperature,  $T_h$ , for monofilament (Bi,Pb)SCCO 2223 tapes fabricated from (a) precursor powders with a predominant orthorhombic (Bi,Pb)SCCO 2212 phase, secondary AEC phases and no  $\text{Ca}_2\text{PbO}_4$  phase and (b) precursor powders with a predominant tetragonal BSCCO 2212 phase, secondary AEC phases, and a  $\text{Ca}_2\text{PbO}_4$  phase;

- FIG. 5 depicts the x-ray diffraction (XRD) pattern of the powder prepared according to Example 1, having an orthorhombic BSCCO-2212 phase and secondary CaO and CuO peaks;

- FIG. 6 depicts the x-ray diffraction (XRD) patterns of the powder prepared according to Example 3, including an orthorhombic BSCCO phase and a secondary  $\text{Ca}_2\text{CuO}_3$  phase; and

- FIG. 7 depicts the x-ray diffraction (XRD) patterns indicating conversion of precursor (Bi,Pb)SCCO 2212 into the final (Bi,Pb)SCCO 2223 phase in composite tapes where the tape was (a) ramped to the reaction temperature at a rate of 10°C/min and the tapes of (b) and (c) were ramped to the reaction temperature at a rate of 1°C/min.

#### Detailed Description of the Invention

- The present invention provides a precursor powder, useful in the preparation of BCSSO superconducting materials and composites, which include a dominant amount of an orthorhombic BSCCO phase and,

optionally, an alkaline earth cuprate (AEC). The method of the present invention provides an intimate mixture of the two phases (orthorhombic BSCCO phase and AEC) which can not be obtained by prior art methods of mixing individual sources of the two materials.

- 5 The method of the present invention includes an optimized process for preparing a precursor powder including a dominant amount of an orthorhombic BSCCO phase, and an optimized thermal processing method that maintains the selected phase composition of the precursor powder, reduces the formation of undesirable secondary phases during conversion  
10 of the powder into the final superconducting material and enhances the formation of substantially single phase, highly textured forms of the final superconducting material.

- According to the method of the invention, a process for preparing a precursor powder is described, in which control of processing conditions,  
15 such as temperature and oxygen partial pressure, provide a precursor powder which contains a dominant amount of an orthorhombic BSCCO phase. The orthorhombic BSCCO phase typically may include BSCCO 2212. It may also include a doped BSCCO 2212 such as, by way of example only, (Bi,Pb)SCCO 2212 or (Bi,Sb)SCCO. The addition of a  
20 dopant to the BSCCO phase is believed to promote the conversion of the tetragonal BSCCO phase to the more desirable orthorhombic BSCCO 2212 phase under the reaction conditions of the present invention.

- According to the method of the present invention, undesirable secondary phases are also minimized. By "undesirable secondary phase", as  
25 that term is used herein, it is meant phases in the precursor powder which do not promote or which hinder the conversion of the precursor powder into the final BSCCO superconducting material. "Undesirable" secondary phases are contrasted to "desirable" secondary phases, the latter of which are necessary for the conversion of the precursor into the final  
30 superconducting material. Suitable desirable secondary phases include

- alkaline earth cuprates and/or copper oxides which react with the orthorhombic BSCCO phase to form a higher order family member of the BSCCO homologous series of superconducting oxides. "Undesirable secondary phases" may include unreacted metal oxides, such as alkaline
- 5 earth bismuthates or alkaline earth plumbate, or lower members of the homologous series of which the final BSCCO superconductor is a member, for example, BSCCO 2201. In the (Bi,Pb)BSCCO system, the presence of a Ca-Pb-O secondary phase, i.e.,  $\text{Ca}_2\text{PbO}_4$ , is undesirable because it can produce large unwanted secondary phases which are unproductive in the
- 10 formation of the final superconductor phase (by reaction of the BSCCO phase without incorporation of lead into the product) and thereby reduce the rate of formation of (Bi,Pb)SCCO 2223.

- According to the method of the invention, a raw powder mixture is produced by mixing appropriate amounts of raw powder in a
- 15 stoichiometry suitable for production of a desired final phase. Suitable raw powders include, but are not limited to, oxides, carbonates, oxalates, alkoxides or nitrates of Bi, Sr, Ca and Cu, and optionally Pb or Sb. After thoroughly mixing the raw materials, the mixture is subjected to multiple heating and grinding steps in order to obtain a uniform mixture of the
- 20 metallic elements, reduce the particle size and eliminate by-products such as oxides of nitrogen or carbon. Depending on the starting material and the particle size, there are usually one to four initial heating and grinding steps. Typically, the raw powders are heated at a temperature in the range of 350°C to 800°C, in air or oxygen atmosphere, followed grinding of the
- 25 powder to a small particle size. Alloying of the constituent metallic elements of the final oxide superconductor is also contemplated within the scope of the present invention.

- Thereafter, the raw powder mixture is reacted to form the precursor powder of the present invention, which includes a dominant amount of an
- 30 orthorhombic BSCCO phase. Processing temperature and oxygen partial

- pressure are selected such that the formation of an orthorhombic BSCCO phase (among the other possible BSCCO phases) will dominate. It is, of course, contemplated that secondary phases necessary for the conversion of the orthorhombic BSCCO phase into the final superconducting phase may be present in the precursor phase.

- According to the method of the invention, the raw powder may be heated to a processing temperature,  $T_p$ , in the range of 650°C to 795°C in a controlled atmosphere of an inert gas and a selected oxygen partial pressure,  $P(O_2)$ , between  $10^{-3}$  atm  $O_2$  and 0.04 atm  $O_2$ . Suitable inert gases include, by way of example only, nitrogen and argon. The temperature may be increased at a ramp rate between 0.5°C per minute and 200°C per minute up to the processing temperature,  $T_p$ , and the mixture may be kept at  $T_p$  for a period of 0.1 to 60 hours.

- The appropriate values for  $T_p$  and  $P(O_2)$  may be selected by monitoring the effect of processing conditions by XRD. The presence of the orthorhombic structure is indicated by the splitting of the XRD peak at 33°(2 $\theta$ ). In the related tetragonal structure, the XRD 200 and 020 peaks at 33°(2 $\theta$ ) appears as a singlet. These differences in the x-ray diffraction pattern reflect the real structural differences in the two phases. The two phases further may be distinguished by comparison of their lattice parameters, where there is a decrease in the c-axis in the orthorhombic structure as compared to the tetragonal structure. Furthermore,  $P(O_2)$  and  $T_p$  control the relative formation of metal oxides secondary phase, including  $(Sr,Ca_{1-x})CuO_x$ ,  $(Sr,Ca_{1-x})_2CuO_3$ ,  $CuO$ ,  $CaO$ , and  $Cu_2O$ .

- For those systems which include lead (Pb), the  $O_2$  partial pressure is maintained below a  $P(O_2)$  value at which the  $Ca_xPbO_4$  phase is formed and above a  $P(O_2)$  value at which the  $(Bi,Pb)SCCO$  2212 phase decomposes by reduction of  $Cu^{2+}$  to  $Cu^{1+}$ . By operating in a processing regime which is bracketed by a lower  $P(O_2)$  defining the phase stability region of  $(Bi,Pb)SCCO$  2212 and a higher  $P(O_2)$  defining a region below which

$\text{Ca}_2\text{PbO}_4$  will not form, phase composition of the precursor powder can be controlled and optimized.

- The appropriate values of  $T_p$  and  $P(\text{O}_2)$  may be selected based on the diagram shown in FIG. 1, so that substantially no  $\text{Ca}_2\text{PbO}_4$  is formed in the precursor powder mixture. The diagram displays a dependence of the relative amount of the  $\text{Ca}_2\text{PbO}_4$  phase on the values of  $T_p$  and  $P(\text{O}_2)$ , with relative  $\text{Ca}_2\text{PbO}_4$  formation denoted by topical lines ranging from 0 (no  $\text{Ca}_2\text{PbO}_4$  formation) to 1.0 (exclusive  $\text{Ca}_2\text{PbO}_4$  formation). A higher  $T_p$  value permits a higher  $P(\text{O}_2)$  value without forming  $\text{Ca}_2\text{PbO}_4$ . For example, only insignificant amounts of  $\text{Ca}_2\text{PbO}_4$  are formed under reaction conditions of 750°C and 0.01 atm oxygen (indicated by point 10 in FIG. 1), whereas at the reaction temperature of 810°C, no significant amount of  $\text{Ca}_2\text{PbO}_4$  is formed at oxygen pressures as high as 0.05 atm (indicated by point 12 in FIG. 1). Also, at very low  $T_p$  (<600°C), the formation of  $\text{Ca}_2\text{PbO}_4$  is thermodynamically disfavored over a wide range of  $\text{PO}_2$  (0.0001 - 0.21 atm).

- The dominant amount of orthorhombic phase advantageously includes more than 50 percent by volume (%vol), preferably more than 80 %vol and most preferably more than 95 %vol of the BSCCO phase in the orthorhombic phase. Typically, the volume fraction of orthorhombic phase will be either greater than 95% (the detection limit of XRD) or it will not be present at all because the dopant carrier oxide phase will act as an oxygen buffer, thereby keeping the effective  $P(\text{O}_2)$  low and preventing phase conversion from tetragonal to orthorhombic. Once the secondary phase containing the dopant has been eliminated, substantially complete conversion to the orthorhombic phase occurs.

- The volume fraction of the BSCCO phase having the orthorhombic structure may be determined readily by XRD analysis. The ratio of the intensity of the single peak at 33°(2 $\theta$ ) to the split peak at 33°(2 $\theta$ ) will show the relative amounts of the two phases. Further, in instances, where lead

- is present, the relative amount of the tetragonal phase may be determined by taking a ratio of the peak at  $17.5^\circ(2\theta)$ , corresponding to  $\text{Ca}_2\text{PbO}_4$ , to the single peak at  $33^\circ(2\theta)$ , corresponding to the orthorhombic  $(\text{Bi,Pb})\text{BSiCO}$  phase. In the case where a dopant other than lead is used, peaks unique to the secondary phase incorporating that dopant may be used.

- The mixture of the primary  $(\text{Bi,Pb})\text{SCCO}$  2212 phase and the AEC phases forms a precursor powder which may be used for production of  $(\text{Bi,Pb})\text{SCCO}$  2223 or 2212 superconducting wires and tapes using the OPIT method. In the composite precursor fabrication stage of the PIT process, a superconducting composite precursor is formed by packing the precursor powder into a sheath comprising a noble metal layer, reducing the cross-section of the composite by one or more reduction passes, optionally rebundling, and again reducing the composite cross-section.
- In accordance with the PIT method, the precursor powder is packed into a silver sheath to form a billet. The billet is extruded to a diameter of about 1/3 of the original diameter and then narrowed with multiple die passes. A mono-filamentary tape is fabricated by further extrusion and/or drawing of the billet to a wire, and then rolling the wire, for example, to a  $0.006" \times 0.100"$  tape. Alternatively, a multi-filamentary tape may be fabricated by multiple die passes through hexagonally shaped dies of varying sizes to form a silver sheathed  $(\text{Bi,Pb})\text{SCCO}$  hexagonal wire. Several of the hexagonal wires may be bundled together and drawn through a round die to form a multi-filamentary round wire. The round wire may then be rolled, for example, to form a multi-filamentary silver and  $(\text{Bi,Pb})\text{SCCO}$  composite precursor tape of  $0.009" \times 0.100"$ .

- The composite may be textured using by one or more deformation steps. The deformation steps induce texturing of the selected orthorhombic phase of the precursor powder contained in the composite.
- Throughout the drawing and deformation steps, intermediate annealing



steps may be performed. The anneal steps are advantageously carried out at temperatures and under oxygen partial pressures which prevent decomposition of the orthorhombic BSCCO phase or formation of  $\text{Ca}_2\text{PbO}_4$  (See, FIG. 1).

- 5       The composite fabrication method of the present invention envisions several mechanical deformation iterations. The strain applied during the deformation improves the grain alignment for each iteration. The rolling process may be replaced by pressing, isostatic pressing, drawing, swaging, extrusion or forging. Thermal annealing may be used  
10 after any significant mechanical deformation or reshaping of the superconducting composite for improvement of mechanical properties. Applicants have discovered that annealing conditions used in the prior art typically convert the orthorhombic BSCCO phase into the tetragonal phase with the concomitant formation of  $\text{Ca}_2\text{PbO}_4$ . This occurs under  
15 prior art treatments, even when the precursor powder is originally substantially free of  $\text{Ca}_2\text{PbO}_4$  (by virtue of mixing of separate powders). Advantageously, the anneal of the present invention may be performed at processing conditions (T, P( $\text{O}_2$ )) selected to prevent the conversion of the orthorhombic 2212 phase to the tetragonal 2212 phase in order to preserve  
20 the advantages of the selected phases of the starting precursor powder.

- Fig. 2 illustrates how annealing steps typically involved in the deformation process can alter the phase composition of the precursor powder. Three precursor composite tapes were prepared from a precursor powder containing a predominant orthorhombic  $(\text{Bi,Pb})\text{SCCO}$  2212 phase  
25 and secondary AEC phases. The three tapes were annealed at different temperatures in nitrogen ( $<10^{-4}$  atm  $\text{O}_2$ ) or in air (0.21 atm  $\text{O}_2$ ) and the effect of the anneal conditions on the tape composition was observed. The first tape, annealed at 400°C in air for one hour, showed no discernible formation of tetragonal  $(\text{Bi,Pb})\text{BSCCO}$  2212, as indicated by the absence of  
30 a single XRD peak at  $33^\circ(2\theta)$  (not shown) and the absence of a  $\text{Ca}_2\text{PbO}_4$

XRD peak at  $17.8^\circ$  ( $2\theta$ ) in curve 10 of FIG 2. Arrow 11 indicates the anticipated location of  $\text{Ca}_2\text{PbO}_4$  peak. The second tape, annealed at  $600^\circ\text{C}$  in nitrogen for one hour, also showed no discernible formation of tetragonal  $(\text{Bi,Pb})\text{BSCCO}$  2212 or  $\text{Ca}_2\text{PbO}_4$ , as evidenced by XRD in curve 12. This is in agreement with the data shown in FIG. 1. However, the third tape, annealed at  $600^\circ\text{C}$  in air, formed tetragonal  $(\text{Bi,Pb})\text{BSCCO}$  2212 and  $\text{Ca}_2\text{PbO}_4$ , as evidenced by the presence of a peak at  $17.8^\circ$  ( $2\theta$ ) in curve 14, which is a signature of  $\text{Ca}_2\text{PbO}_4$ .

The effect of different precursor phases on the deformation properties of the composite precursor was studied with two monofilamentary tapes, fabricated by the OPIT method using an identical deformation process for composites containing two different precursor powders. The first tape included a precursor powder with a predominant orthorhombic  $(\text{Bi,Pb})\text{SCCO}$  2212 phase, secondary AEC phases and no  $\text{Ca}_2\text{PbO}_4$  phase. The second tape included a precursor powder with a predominant tetragonal BSCCO 2212 phase, secondary AEC phases, and a  $\text{Ca}_2\text{PbO}_4$  phase. FIG. 3 depicts the XRD patterns of the deformed precursor powder composite tapes. Curve 20 represents the XRD pattern for the tape containing tetragonal  $(\text{Bi,Pb})\text{SCCO}$  2212 and curve 22 represents the XRD pattern for the tape containing orthorhombic  $(\text{Bi,Pb})\text{SCCO}$  2212. The degree of texturing of the selected primary phase (either tetragonal or orthorhombic  $(\text{Bi,Pb})\text{SCCO}$  2212) is indicated by the relative intensities of the labeled peaks 24 compared to the intensities of the remaining peaks of the 2212 phase. The higher the ratio, the larger is the degree of texture. Although the two tapes were subjected to identical deformation processing steps, the orthorhombic  $(\text{Bi,Pb})\text{SCCO}$  2212 phase undergoes higher texturing.

The effect of different precursor phases on the properties of the composite precursor was studied by measuring the microhardness in the center of the deformed precursor tape. A tape including a precursor

powder with a dominant amount of orthorhombic  $(\text{Bi,Pb})\text{SCCO}$  2212 phase, secondary AEC phases and no  $\text{Ca}_2\text{PbO}_4$  phase had a microhardness value of about 150 KHN. A tape including a precursor powder with a dominant amount of tetragonal  $\text{BSCCO}$  2212 phase, secondary AEC phases, and a  $\text{Ca}_2\text{PbO}_4$  phase had a microhardness of about 95 KHN. Microhardness reflects the intrinsic hardness of the phase, the porosity of the powder, the texturing, and the intergranular coupling. Thus, the tape made from the orthorhombic  $(\text{Bi,Pb})\text{SCCO}$  2212 phase is expected to show more rapid conversion to the final 2223 phase while retaining a higher degree of texture and grain density.

Besides the thermal annealing processes associated with the deformation processes, any thermal processing of the tape can result in changes in the phase content of the precursor powder. Thus it is desirable to control the selected phase content of the precursor powder in the composite by cooperatively selecting the oxygen partial pressure and the temperature of any heating process such that the oxidation state of the constituent elements of the selected primary phase are not changed.

The thermal heating process of the present invention involves heating the deformed composite to a reaction temperature,  $T_0$ , where the final superconducting phase, such as BSCCO 2223, is formed. In order to heat the composite to the desired  $T_0$  without altering the selected phase content of the precursor powder, it is necessary to cooperatively maintain the temperature, oxygen partial pressure and reaction time at reaction conditions that will effect conversion of the precursor to the final superconducting oxide without effecting the decomposition of the orthorhombic BSCCO phase. (See FIG. 1.) According to the method of the invention, the precursor powders may be heated at a temperature in the range of 800°C to 845°C, and more preferably 800°C to 834°C, at an oxygen pressure in the range of .003 atm to 0.21 atm in order to convert

the precursor to the final superconductor phase without adversely affecting phase composition of the precursor during the heat treatment.

Typically, the tape is heated to a temperature in the range of 650°C to 795°C in an inert atmosphere with a reduced O<sub>2</sub> partial pressure between 0.0001 atm and 0.075 atm. The selected ramp rate is in the range of 0.1°C per minute to 50°C per minute. The temperature and oxygen partial pressure ranges are selected to prevent subjecting the composite to conditions moving through a regime where the orthorhombic BSCCO phase is thermodynamically unstable (again, see FIG. 1). It is also within the scope of the invention to ramp the composite through temperature and oxygen partial pressure ranges at which the formation of Ca<sub>2</sub>PbO<sub>4</sub> is thermodynamically favored and the orthorhombic BSCCO phase is thermodynamically unstable, but at a ramp rate (change in temperature and oxygen pressure with time) such that Ca<sub>2</sub>PbO<sub>4</sub> is kinetically disfavored (i.e., the composite is not subjected to such conditions for enough time to form Ca<sub>2</sub>PbO<sub>4</sub>).

Once the temperature is sufficiently high, the partial pressure of O<sub>2</sub> may be continuously or abruptly increased to a higher value, in the range of 0.01 atm O<sub>2</sub> to 0.21 atm O<sub>2</sub>, used for the (Bi, Pb)SCCO 2223 formation. This oxygen partial pressure is suitable for the conversion of the precursor to the final oxide superconductor, yet will not destabilize the orthorhombic phase at temperatures above 790°C. The selected conversion temperature, T<sub>B</sub>, in the range of 790°C to 845°C may be reached at a ramp rate in the range of 0.5°C per minute to 10°C per minute. The tape is maintained at T<sub>B</sub> for about 1 to 60 hours to form the desired 2223 phase. Then, the superconducting tape is cooled to room temperature.

The effect of phase composition of the precursor powder on the critical current I<sub>c</sub> of the final superconductor article was studied. Monofilamentary tapes were fabricated by the OPIT method using an identical

- deformation process which contained either a precursor powder with a predominant orthorhombic (Bi,Pb)SCCO 2212 phase, secondary AEC phases and no  $\text{Ca}_2\text{PbO}_4$  phase, or a precursor powder with a predominant tetragonal BSCCO 2212 phase, secondary AEC phases, and a  $\text{Ca}_2\text{PbO}_4$  phase. The precursor powder composite tapes were thermally converted into the final superconductor ((Bi,Pb) SCCO 2112) at process temperatures in the range of 810°C to 830°C in an environment containing a oxygen partial pressure of 0.075 atm. Critical current of the resultant tapes were determined and are depicted as a plot of critical current  $I_c$  v. processing temperature in FIG. 4. Curve 30 represents the critical current of tapes processed from precursor powders containing the orthorhombic (Bi,Pb)SCCO 2212 phase. Curve 32 represents the critical current of tapes processed from precursor powders containing the tetragonal (Bi,Pb)SCCO 2212 phase. The critical current of tapes represented by curve 30 (orthorhombic (Bi,Pb)SCCO 2212) is superior to that of tapes processed from tetragonal (Bi,Pb)SCCO 2212 phase (curve 32) at all temperatures.

- Also noteworthy is that precursor powders containing  $\text{Ca}_2\text{PbO}_4$  (curve 32) have a narrower optimal processing temperature range, centered about 824°C at the specified  $P_{\text{O}_2}$ , than the precursor powder devoid of  $\text{Ca}_2\text{PbO}_4$  (curve 30). The orthorhombic phase of (Bi,Pb)SCCO 2212 represents substantially complete doping of lead into the BSCCO solid state structure with the concomitant conversion of the lead-free tetragonal phase into the orthorhombic phase. The lead-doped orthorhombic phase readily converts to the final superconductor, (Bi,Pb)SCCO 2223 to give a high quality superconductor over a large temperature range (see FIG. 4, curve 30). In comparison, the lead-free tetragonal BSCCO phase does not convert readily into (Bi,Pb)SCCO 2223, in particular, because it must first dope lead into the BSCCO solid state structure. Doping only occurs around the temperature centered at 824°C at the specified  $P(\text{O}_2)$ .

Additional thermomechanical treatment processes can be employed to more fully convert the composite to the desired final, highly textured superconducting phase, preferably BSCCO 2223. This additional thermomechanical processing may be carried out by any conventional method, such as for example those described in Gao, Sandhage, and U.S. patent applications 08/041,822 filed April 1, 1993, entitled "Improved Processing for Oxide Superconductors," and 08/198,912 filed February 17, 1994, entitled "Improved Processing of Oxide Superconductors", both of which are hereby incorporated by reference as if fully set forth herein.

The following examples further disclose the invention and enable practice thereof:

**Example 1.** In the precursor powder formation stage, a homogenous mixture of Bi, Pb, Sr, Ca and Cu nitrates with metal ratios of 1.7:0.3:1.9:2.0:3.0 was decomposed to the metal oxides by reaction at 800°C for 7 minutes in air. The metal oxide mixture was then milled to reduce the particle size and homogenize the mixture. The milled oxide powder was then reacted in 100% O<sub>2</sub> for 6 hours at 785°C. The reacted oxide mixture was again milled to reduce the particle size. Next, the milled powder was reacted at T<sub>p</sub> = 780°C for 6 hours in an N<sub>2</sub> atmosphere containing 0.001 atm O<sub>2</sub>. Referring to Fig. 5, an X-ray diffraction pattern of the reacted precursor powder shows peaks corresponding to the orthorhombic (Bi,Pb)SCCO 2212 phase, and several non-superconducting phases consisting of mainly the CuO and CaO phases. CaO peaks are indicated by a "+" and CuO peaks are indicated by "\*" in the XRD curve of FIG. 5. The diffraction pattern has no discernible peaks corresponding to Ca<sub>2</sub>PbO<sub>4</sub>. The orthorhombic structure of the dominant Pb2212 is indicated by the splitting of the peak at 2θ = 33.3°. The precursor powder was then used in the OPIT fabrication phase to form a composite precursor for a superconducting wire.

Example 2. In the precursor powder formation stage, a homogeneous mixture of Pb, Bi, Sr, Ca and Cu oxalates with metal ratios of 1.7:0.3:1.9:2.0:3.0 was decomposed to the metal oxides by reaction at 350°C for 20 minutes in air. The metal oxide mixture was then milled to reduce the particle size and homogenize the mixture. The milled oxide powder mixture was then reacted in 100% O<sub>2</sub> for 3 hours at 750°C. The resulting milled oxide powder mixture was reacted at T<sub>p</sub> = 770°C for 3 hours in an N<sub>2</sub> atmosphere containing 0.001 atm O<sub>2</sub>. X-ray diffraction data of the powder showed peaks corresponding to the orthorhombic (Bi,Pb)SCCO 2212 phase, CuO, and alkaline earth cuprate phases. The diffraction pattern exhibited no discernible peaks corresponding to Ca<sub>2</sub>PbO<sub>4</sub>. The mixture was then used as a precursor powder for fabrication of a composite precursor and conversion to a superconducting article in accordance with the OPIT process.

Example 3. In the precursor powder formation stage, a homogeneous mixture of Bi, Pb, Sr, Ca and Cu nitrates with metal ratios of 1.7:0.3:1.9:2.0:3.0 was decomposed to its metal oxides by reaction at 800°C for 7 minutes in air. The metal oxide mixture was then milled to reduce the particle size and to homogenize the mixture. The milled oxide powder was then reacted in 100% O<sub>2</sub> for 3 hours at 750°C. The powder was then reacted at T<sub>p</sub> = 780°C for 6 hours in an N<sub>2</sub> atmosphere containing < 0.0001 atm O<sub>2</sub>. Referring to FIG. 6, an X-ray diffraction pattern of the reacted precursor powder shows the peaks due to the orthorhombic (Bi,Pb)SCCO 2212 phase, Cu<sub>2</sub>O, Ca(Sr)<sub>2</sub>CuO<sub>3</sub>, and possibly other phases. The diffraction pattern exhibits no discernible peaks corresponding to Ca<sub>2</sub>PbO<sub>4</sub>. The mixture was then used as a precursor powder for fabrication of a composite precursor and conversion to a superconducting article in accordance with the OPIT process.

Example 4. In the precursor powder formation phase, a homogeneous mixture of Bi, Pb, Sr, Ca and Cu oxides with metal ratios of

- 1.7:0.3:1.9:2.0:3.0 was reacted at 800°C for 6 hours in 100% O<sub>2</sub> atmosphere. The metal oxide mixture was then milled to reduce the particle size and to homogenize the mixture. The resulting powder was reacted at T<sub>p</sub> = 750°C for 2 hours in an N<sub>2</sub> atmosphere containing 0.1% O<sub>2</sub>. The X-ray diffraction pattern of the reacted precursor powder shows the peaks due to the orthorhombic (Bi, Pb)SCCO 2212 phase, and the alkaline earth cuprate phases including a Ca(Sr)<sub>0.15</sub>CuO<sub>1.85+x</sub> phase. The diffraction pattern exhibits no discernible peaks due to Ca<sub>2</sub>PbO<sub>4</sub>. The mixture was then used as a precursor powder for a powder-in-tube (PIT) process.

- Example 5. A homogeneous precursor alloy powder containing Pb, Bi, Sr, Ca, and Ag was prepared by mechanical alloying with the appropriate stoichiometry to form Bi-2223. The powder was packed into a silver tube along with sufficient copper metal powder or wires to form the Bi-2223 superconductor. The composite was then worked by multiple extrusion steps into a multifilamentary silver precursor metal composite tape that was typically .03" x .15" in cross-section, and that contained between 200 and 100,000 filaments. The reactive elements comprising each filament was then oxidized to form unitary and binary oxide phase such as CaO, CuO, Bi<sub>2</sub>O<sub>3</sub>, PbO and SrO by diffusing oxygen through the silver matrix at conditions (typically at temperature of ~ 400°C) that inhibit reaction element diffusion through the silver. After oxidation, the internal oxygen activity of the composite was then reduced to ~ 0.001 atm equivalent by baking the tape samples for 40 hours at 400°C in flowing 0.001 atm balance nitrogen (to 1 atm total pressure) gas. The desired orthorhombic Bi-2212 precursor phase to Bi-2223 was then formed by baking the samples at 780°C for 1 hour in 0.001 atm oxygen-balance argon (to 1 atm total) followed by rolling deformation. The bake and deformation was repeated up to 6 times. The sample was then used as a precursor composite for the powder-in-tube process.



- Example 6. A precursor powder was prepared as described in Example 1 through 4 and packed into silver sheaths with an inner diameter of 0.625" (1.5875 cm), a length of 5.5" (13.97 cm) and a wall thickness of 0.150" (0.38 cm) to form a billet. The billet is extruded to a diameter of about 0.25" (0.63 cm) and then narrowed with multiple die passes. A mono-filamentary tape is fabricated by further extrusion and/or drawing the billet to a 0.072" wire, and then rolling the wire to a 0.006" x 0.100" tape. A multi-filamentary tape is fabricated by multiple die passes through hexagonally shaped dies of varying sizes finishing with a 0.070" (0.178 cm) hexagonally shaped die to form a silver-(Bi, Pb)SCCO hexagonal wire. Several of the hexagonal wires are bundled together and drawn through a 0.070" (0.178 cm) round die to form a multi-filamentary round wire. The round wire is rolled to form a multi-filamentary silver-(Bi,Pb)SCCO tape of 0.009" x 0.100" (0.023 cm x 0.24 cm). The tape is subjected to iterative processes of alternating heating/annealing and mechanical deformation, as described above.

- The composite tape was heated from ambient temperature to 827°C at a rate of 10°C/min in an atmosphere containing 0.075 atm oxygen and held at that temperature for 10 hours. The tape was then cooled to ambient temperature. An identical tape was heated to 400°C at a rate of 5°C/min and to 827°C at a rate of 1°C/min in an atmosphere containing 0.075 atm O<sub>2</sub> and held at that temperature for 10 hours. Finally a composite tape containing a tetragonal 2212 precursor phase and Ca<sub>2</sub>PbO<sub>4</sub> was fabricated and heated to 400°C at a rate of 5°C/min and to 827°C at a rate of 1°C/min in an atmosphere containing 0.075 atm O<sub>2</sub> and held at that temperature for 10 hours.

- Referring to FIG. 7(a), the x-ray diffraction spectrum of the tape containing the orthorhombic 2212 as the dominant precursor phase and heated at the 10°C/min shows a conversion of ~80% of the dominant Pb2212 phase of the initial precursor powder to the final Pb2223 phase.

In contrast of FIG. 7(b), the x-ray diffraction spectrum of the tape containing the orthorhombic 2212 as the dominant precursor phase and heated at 1°C/min shows a conversion of ~6% of the dominant Pb2212 phase of the initial precursor powder to the final Pb2223 phase. The lower conversion rate was the result of the formation of  $\text{Ca}_2\text{PbO}_4$  and the decomposition of the dominant orthorhombic 2212 during the slow temperature ramp in the temperature and oxygen partial range defined by Figure 1.

In FIG. 7(c), the x-ray diffraction spectrum of the tape containing the tetragonal 2212 and  $\text{Ca}_2\text{PbO}_4$  in the precursor phase and heated at  $1^\circ\text{C}/\text{min}$  shows a conversion of  $\sim 20\%$  of the 2212 phase of the initial precursor powder to the final  $\text{Pb}2223$  phase.

The lower conversion rates in FIGs. 7(c) and 7(b) are the result of the need to form (in 7(c)) or reform (in 7(b)) the orthorhombic Pb2212 phase at the reaction temperature before conversion of Pb2212 to Pb2223 can occur.

**Example 7.** The composite tape was prepared as described in Example VI using a precursor powder prepared as described in Examples 1 - 4. The composite tape was heated from ambient temperature to a 790°C at a rate of 1°C/min in an atmosphere containing 0.001 atm O<sub>2</sub>, then at a rate of 1°C/min to 815°C in an atmosphere containing 0.075 atm O<sub>2</sub> and held at that temperature for 24 hours. The tape is then cooled to ambient temperature. The temperatures and oxygen partial pressures are selected to insure that Ca<sub>3</sub>PbO<sub>4</sub> did not form in the powder during the heating step to the reaction temperature. The x-ray diffraction of the composite tape showed conversion of >50% of the original dominant orthorhombic 2212 phase to the final 2223 phase.

Example 8. In the precursor powder formation stage, a homogenous mixture of Bi, Sb, Sr, Ca and Cu nitrates with metal ratios of 1.7:0.3:1.9:2.0:3.0 was decomposed to the metal oxides by reaction at

800°C for 7 minutes in air. The milled oxide powder was then reacted in 100% O<sub>2</sub> for 6 hours at 785°C. The reacted oxide mixture was again milled to reduce the particle size. Next, the milled powder was reacted at T<sub>p</sub> = 780°C for 6 hours in an N<sub>2</sub> atmosphere containing 0.001 atm O<sub>2</sub>. The resulting precursor mixture contains only the dominant orthorhombic 2212 phase and several non superconducting phases consisting predominantly of alkaline earth cuprates. The orthorhombic structure of the dominant Pb2212 is indicated by the splitting of the peak at 2θ = 33.3°. The precursor powder was then used in the OPTI' fabrication process to form a composite precursor for a superconducting wire.

Other embodiments of the invention will be apparent to those skilled in the art from a consideration of this specification or practice of the invention disclosed herein. It is intended that the specification and examples be considered as exemplary only, with the true scope and spirit of the invention being indicated by the following claims.

## CLAIMS:

1. A method for the production and processing of BSCCO superconducting material comprising the steps of:  
providing a mixture comprising raw materials of a desired ratio of constituent metallic elements corresponding to a final superconducting  
5 BSCCO material; and  
heating said mixture at a selected temperature in an inert atmosphere with a selected oxygen partial pressure for a selected time period,  
wherein said processing temperature and said oxygen partial pressure  
10 are cooperatively selected to form a dominant amount of an orthorhombic BSCCO phase in the reacted mixture.
2. The method of claim 1 wherein said final superconducting material comprises a BSCCO-2223 phase.  
15
3. The method of claim 1 wherein said final superconducting material comprises a (Bi,Pb)SCCO-2223 phase.
4. The method of claim 1, wherein the dominant orthorhombic  
20 phase comprises a BSCCO-2212 phase.
5. The method of claim 1, wherein the dominant orthorhombic phase comprises a doped BSCCO-2212 phase, said dopant substituting for bismuth.  
25
6. The method of claim 5, wherein the dopant is selected from the group consisting of lead (Pb) and antimony (Sb).
7. The method of claim 1, wherein the dominant orthorhombic  
30 phase comprises a (Bi,Pb)SCCO-2212 phase.

8. The method of claim 1, 2 or 3, wherein, during said heating step, said processing temperature and said oxygen partial pressure are cooperatively selected to form an alkaline earth cuprate phase, in addition to said dominant orthorhombic BSCCO phase.

5

9. The method of claim 3 or 7, wherein, during said heating step, said processing temperature and said oxygen partial pressure are cooperatively selected such that the oxygen partial pressure is below a value at which a Ca-Pb-O phase is formed and above a value at which said dominant orthorhombic phase decomposes.

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10. The method of claim 1, 2 or 3, wherein said heating step comprises the step of maintaining the temperature of said mixture in a range of 650°C to 795°C and said oxygen partial pressure in a range of  $10^5$  atm  $O_2$  to 0.04 atm  $O_2$ .

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11. The method of claim 1, 2 or 3, wherein said heating step comprises the step of maintaining the temperature of said mixture in a range of 720°C to 790°C and the oxygen partial pressure in a range of  $10^4$  to  $10^2$  atm  $O_2$ .

20

12. The method of claim 1 or 3, further comprising the step of: grinding the reacted mixture; and  
subjecting the ground reacted mixture to said heating step.

25

13. The method of claim 1 or 3, wherein said raw materials are selected from the group consisting of one or more oxides, oxalates, alkoxides, nitrates and carbonates the constituent metallic elements of the final superconducting material.

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- 28 -

providing a mixture of raw materials of a desired ratio of constituent metallic elements corresponding to a final superconducting (Bi,Pb)-Sr-Ca-Cu-O material; and

- 5 heating said mixture at a selected processing temperature in an inert atmosphere with a selected oxygen partial pressure for a selected time period,

wherein said processing temperature and said oxygen partial pressure are cooperatively selected to eliminate, substantially, formation of a Ca-Pb-O phase during said heating step.

10

22. The method of claim 21, wherein, during said heating step, said processing temperature and said oxygen partial pressure are cooperatively selected to form an alkaline earth cuprate phase, in addition to eliminating, substantially, formation of a Ca-Pb-O phase.

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23. The method of claim 21, wherein, during said heating step, said processing temperature and said oxygen partial pressure are cooperatively selected such that the oxygen partial pressure is below a value at which a Ca-Pb-O phase is formed.

20

24. The method of claim 21, wherein said heating step comprises the step of maintaining the temperature of said mixture in a range of 650°C to 795°C and said oxygen partial pressure in a range of  $10^{-5}$  atm  $O_2$  to 0.04 atm  $O_2$ .

25

25. The method of claim 21, wherein said heating step comprises the step of maintaining the temperature of said mixture in a range of 720°C to 790°C and the oxygen partial pressure in a range of  $10^{-4}$  to  $10^{-2}$  atm  $O_2$ .

30

26. The method of claim 21, further comprising the step of:  
grinding the reacted mixture; and  
subjecting the ground reacted mixture to said heating step.
- 5 27. The method of claim 21, wherein said raw materials are  
selected from the group consisting of one or more oxides, oxalates,  
alkoxides, nitrates and carbonates the constituent metallic elements of the  
final superconducting material.
- 10 28. The method of claim 21, wherein said raw materials comprise  
an alloy of the constituent metallic elements of the final superconducting  
material.
- 15 29. A precursor (Bi,Pb)-Sr-Ca-Cu-O superconducting material  
made by the method of claim 21, used for fabrication of an elongated  
superconducting article.
30. A method of fabrication of an elongated (Bi,Pb)-Sr-Ca-Cu-O  
superconducting article comprising the steps of:  
20 providing a mixture of raw materials of a desired ratio of  
constituent metallic elements corresponding to a final superconducting  
(Bi,Pb)SCCO 2223 material;  
heating said mixture at a first selected processing temperature in an  
inert atmosphere with a first selected oxygen partial pressure for a first  
25 selected time period, said first processing temperature and said first oxygen  
partial pressure being cooperatively selected to form a dominant amount of  
an orthorhombic (Bi,Pb)SCCO 2212 phase in the reacted mixture;  
introducing said reacted mixture into a metal sheath, and sealing said  
reacted mixture within said sheath;



deforming said sealed sheath to form an elongated precursor article of a desired texture; and

- heating said orthorhombic (Bi,Pb)SCCO 2212 phase after the deforming step at a second selected processing temperature in an inert atmosphere with a second selected oxygen partial pressure for a second selected time period, said second processing temperature and said second oxygen partial pressure being cooperatively selected to convert at least a portion of said orthorhombic (Bi,Pb)SCCO 2212 phase to said (Bi, Pb)SCCO 2223 superconducting material.

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31. A method of fabrication of an elongated BSCCO superconducting article comprising the steps of:

- providing a mixture of raw materials of a desired ratio of constituent metallic elements corresponding to a final superconducting BSCCO material;

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heating said mixture at a first selected processing temperature in an inert atmosphere with a first selected oxygen partial pressure for a first selected time period, said first processing temperature and said first oxygen partial pressure being cooperatively selected to form a dominant amount of an orthorhombic BSCCO phase in the reacted mixture;

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introducing said reacted mixture into a metal sheath, and sealing said reacted mixture within said sheath;

deforming said sealed sheath to form an elongated precursor article of a desired texture; and

- heating said orthorhombic BSCCO phase at a second selected processing temperature in an inert atmosphere with a second selected oxygen partial pressure for a second selected time period, said second processing temperature and said second oxygen partial pressure being cooperatively selected to convert at least a portion of said orthorhombic BSCCO phase to said final superconducting BSCCO material.

30

32. The method of claim 30 wherein, during said first heating step, said first processing temperature and said first oxygen partial pressure are cooperatively selected to form a dominant amount of an alkaline earth cuprate phase, in addition to said dominant orthorhombic (Bi,Pb)SCCO 2212 phase.

33. The method of claim 30 or 31, wherein said deforming step comprises rolling, pressing, isostatic pressing, drawing, swaging, extrusion or forging.

34. The method of claim 30 or 31, further comprising: the steps of sequentially repeating said deforming and second heating steps.

35. The method of claim 30, wherein said heating step comprises: cooperatively selecting said second processing temperature and said second oxygen partial pressure, such that oxygen partial pressure is below a value at which a Ca-Pb-O phase is formed and above a value at which said dominant orthorhombic (Bi,Pb)SCCO 2212 phase decomposes.

36. The method of claim 30 or 31, wherein said second heating step comprises: heating at a temperature in the range of 800°C to 845°C and at an oxygen pressure in the range of 0.003 to 0.21 atm O<sub>2</sub>.

37. The method of claim 30 or 31, wherein said second heating step comprises: heating at a first temperature in the range of 650°C to 795°C and at a first oxygen pressure in the range of 0.0001 to 0.075 atm O<sub>2</sub>; and

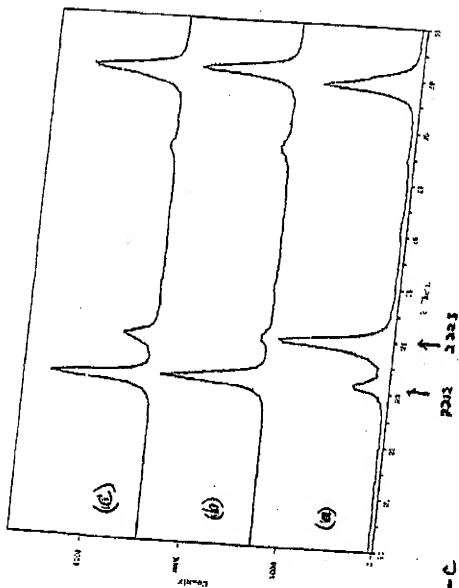


Fig 7 a-c

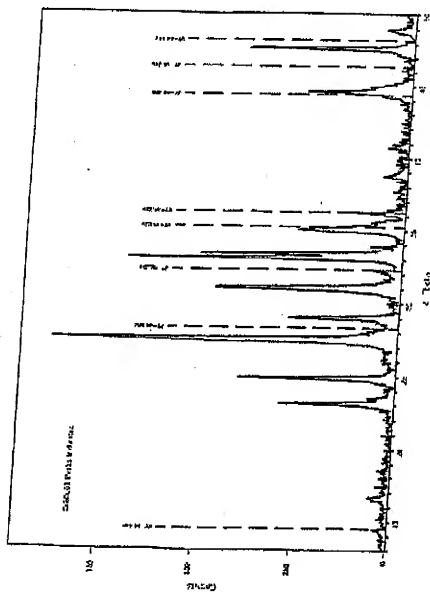


Fig 6

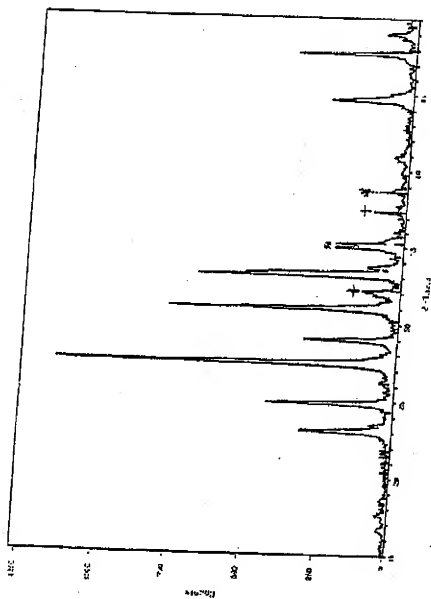


FIG. 5

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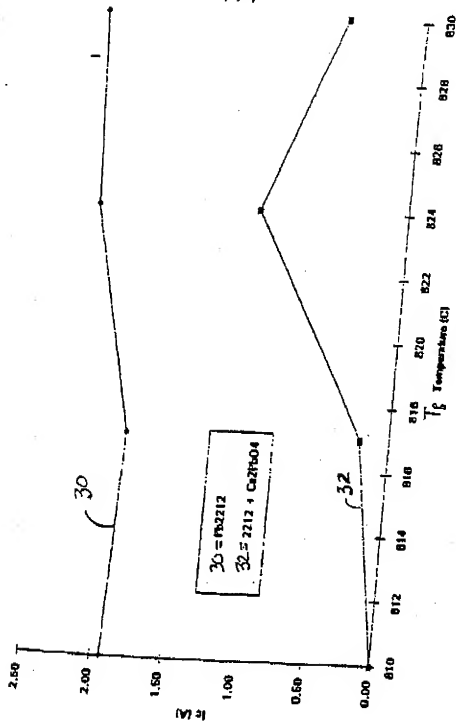


Fig. 4

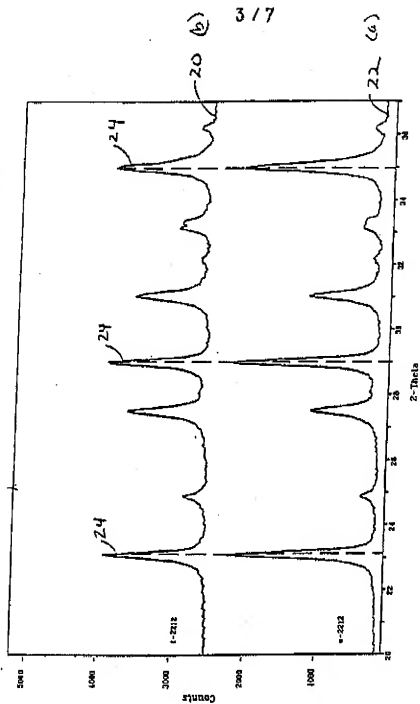


FIG. 3

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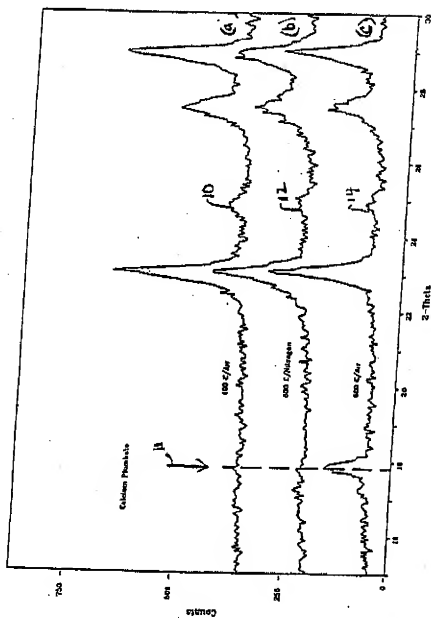


FIG. 2



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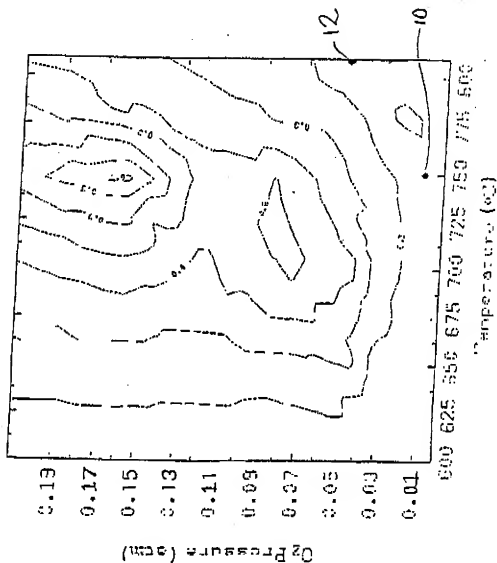


FIG. 1

heating at a second temperature in the range of 800°C to 845°C and at a second oxygen pressure in the range of 0.003 to 0.21 atm O<sub>2</sub>.

38. The method of claim 30, wherein said second heating step  
5 comprises:

ramping through a temperature range and an oxygen partial pressure range, said temperature and oxygen partial pressure range cooperatively including a value at which a Ca-Pb-O phase is formed and/or a value at which said dominant orthorhombic (Bi,Pb)SCCO 2212 phase decomposes,  
10 said ramping at a rate sufficiently rapid such that the formation of the Ca-Pb-O phase and decomposition of the dominant orthorhombic (Bi,Pb)SCCO 2212 phase is kinetically disfavored.

39. The method of claim 38, wherein said ramp rate is greater  
15 than 0.1 °C/min.

40. The method of claim 38, wherein said ramp rate is in the range of 0.1 to 100 °C/min.